Work Order ID 61857

Wednesday, September 08, 2010 9:47:43 AM

Item ID: D2221 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: 350 Basket Base

Start Date: 9/8/2010 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 9/24/2010 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** M **Date:** 10-9-08 **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2221	Rev H								
100		0.00							
Large Fab	Large Fab								
Large Fab	**Memo**	0.00							
Large Fab	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S. Rod Batch: 4114649								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	**Memo**	0.00							
Quality Control									

SM 10/09/30 (1X)

10.09.30

1 SP

PD 10.10.01

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE

Work Order ID 61857

Wednesday, September 08, 2010 9:47:43 AM

Item ID: D2221 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: 350 Basket Base

Start Date: 9/8/2010 **Start Qty:** 1.00 **Cust Item ID:**

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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				40			
QC	**Memo**	0.00 10/10/01							
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00 PR 10-10-5							
HandFinish	**Memo**	0.00				D. P.			
Hand Finishing									

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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NOTE: Date & initial all entries

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Revision ID:

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
Powdercoat									
Powder Coating	**Memo**	0.00 BL 10-10-5				①			

1- Plug holes prior to MM15291
1ST COAT:
START TIME: 1:30
OVEN TEMPERATURE: 400°
FINISH TIME: 2:00
********** 2nd coat if necessary **********
2ND COAT:
START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

140	QC3- Inspect Part Finish	0.00							
QC									
Quality Control	**Memo**	0.00							

EB 10/10/12 ②

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Work Order ID 61857

Wednesday, September 08, 2010 9:47:43 AM

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Item Name: 350 Basket Base

Start Date: 9/8/2010 **Start Qty:** 1.00 **Cust Item ID:**

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Run Start

Stop

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: C-A	0.00							
Packaging	**Memo** w/o 61856	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

10/10/12

10/10/12

MF 10-10-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 08, 2010 9:47:47 AM

Work Order ID: 61857

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 9/8/2010 **Required Date:** 9/24/2010

Start Qty: 1.00 **Required Qty:** 1.00

Comments:
IPP Rev:J 05.09.02 Added D3442-1 □KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2221-1 Rib		Manufactured	No			100	Each	6.0000	1	1		10/09/27	
				Location		**Loc Qty**		**Loc Code**					
				WA		6							
					61091	6				①			
✓ D2221-5 Rib		Manufactured	No			100	Each	6.0000	2	2		10/09/27	
				Location		**Loc Qty**		**Loc Code**					
				WA		6							
					60957	6				②			
✓ D2221-7 Rib		Manufactured	No			100	Each	3.0000	1	1		10/09/27	
				Location		**Loc Qty**		**Loc Code**					
				WA		3							
					61180	3				①			
✓ D2232-3 Basket Hinge		Manufactured	No			100	Each	4.0000	2	2		10/09/27	
				Location		**Loc Qty**		**Loc Code**					
				WA		4							
					61182	4				②			

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W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, September 08, 2010 9:47:47 AM

Work Order ID: 61857

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 9/8/2010 **Required Date:** 9/24/2010

Start Qty: 1.00 **Required Qty:** 1.00

✓ D2235-1 Basket Rib	Manufactured	No		100	Each	8.0000	2	2	B61471 ② MM 10/09/27

Location	Loc Qty	Loc Code
WA	8	
61183	8	

✓ D2581 Mounting Bracket	Manufactured	No		100	Each	41.0000	2	2	MM 10/09/27

Location	Loc Qty	Loc Code
WA	41	
60198	6	
60470	35	②

✓ D3442-1 Shim	Manufactured	No		100	Each	18.0000	2	2	MM 10/09/27

Location	Loc Qty	Loc Code
WA	18	
60177	6	②
61181	12	

✓ D3825-041 Rib Assembly (Basket End)	Manufactured	No		100	Each	4.0000	2	2	MM 10/09/27

Location	Loc Qty	Loc Code
WA	4	
61179	4	②

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Picklist Print

Wednesday, September 08, 2010 9:47:47 AM

Work Order ID: 61857

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 9/8/2010 **Required Date:** 9/24/2010

Start Qty: 1.00 **Required Qty:** 1.00

✓ D3826-041	Manufactured	No		100	Each	4.0000	2	2	
Rib / Gusset Assembly									LM 10/09/27
	Location		**Loc Qty**	**Loc Code**					
	WA		4						
		61178	4						(2)
✓ D3827-041	Manufactured	No		100	Each	5.0000	1	1	
Rib Assembly (Inboard)									LM 10/09/27
	Location		**Loc Qty**	**Loc Code**					
	WA		5						
		61177	5						(1)
✓ D3832-1	Manufactured	No		100	Each	1.0000	1	1	
Mesh (Base)									LM 10/09/29
	Location		**Loc Qty**	**Loc Code**					
	WA		1						
		61022	1						(1)
✓ D3833-1	Manufactured	No		100	Each	8.0000	2	2	
Mesh (Base End Face)									LM 10/09/29
	Location		**Loc Qty**	**Loc Code**					
	WA		8						
		61285	8						(2)

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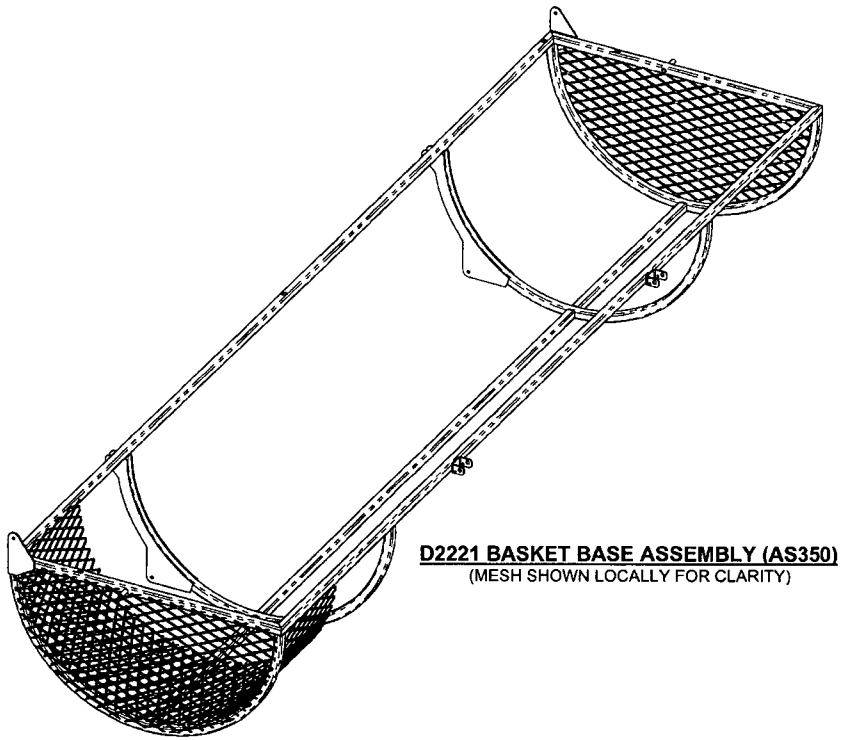
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	**BASKET BASE ASSEMBLY (AS350)**
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 61857
B/O 9-08

RELEASED
08/11/18 MB

REV.	DESCRIPTION	BY	DATE
H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT: 42.00 lbs APPROX
9) MASK ALL HOLES PRIOR TO POWDER COATING

DESIGN	BW	**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 1 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

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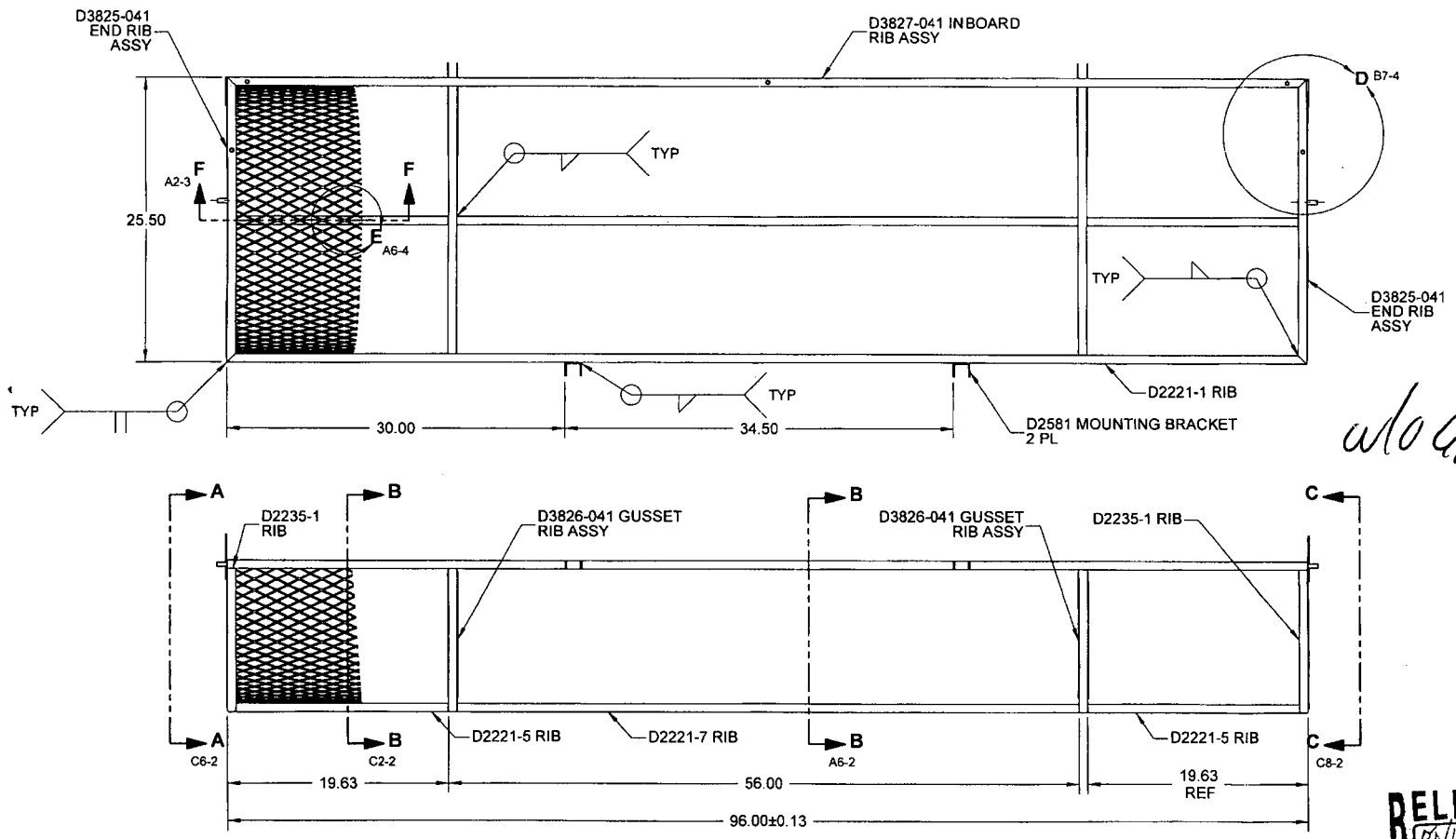
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DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



w/o 41857

RELEASED
08/11/18 MM

D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	BW	**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 2 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

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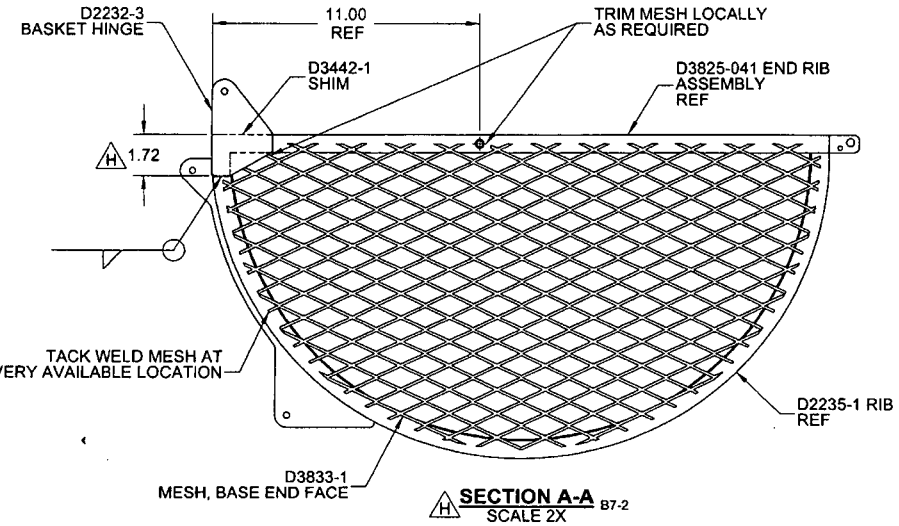
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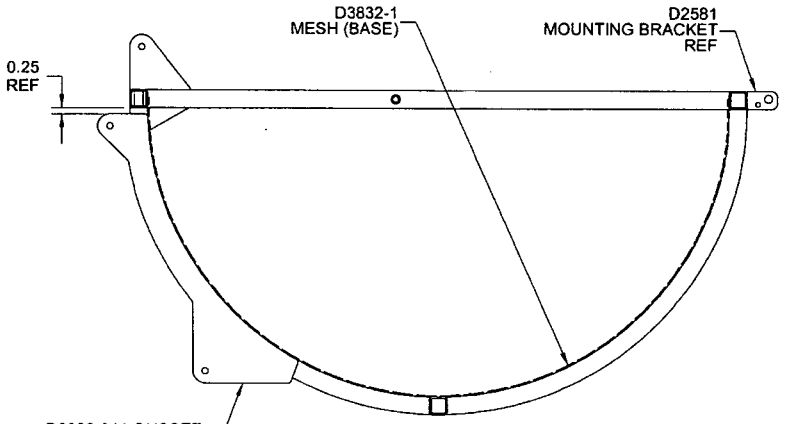
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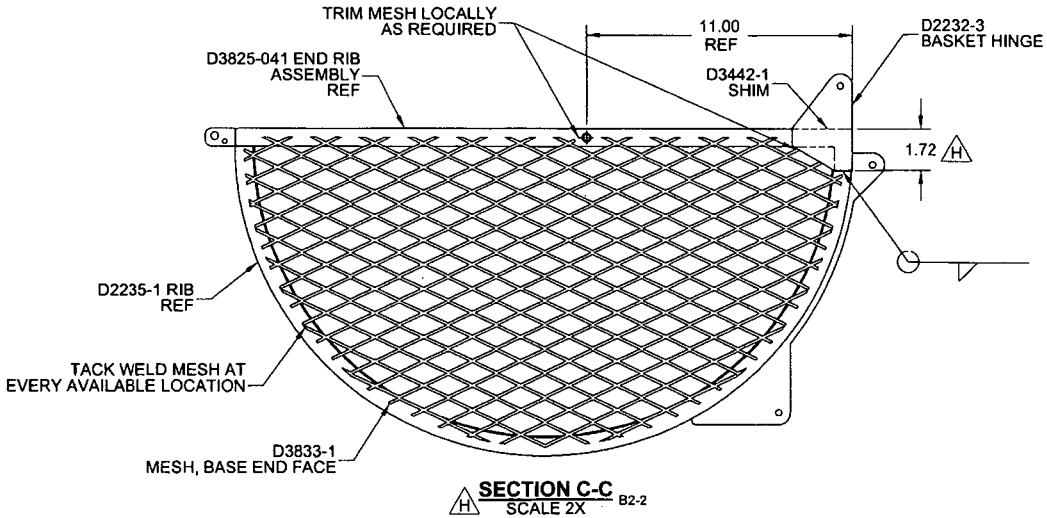
NOTE: Date & initial all entries



H **SECTION A-A** B7-2
SCALE 2X



H **SECTION B-B** B6-2 B4-2
(D3833-1 MESH NOT SHOWN FOR CLARITY)
SCALE 2X



H **SECTION C-C** B2-2
SCALE 2X

W/O G1857

RELEASED
08/11/18

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. D2221 REV. H
CHECKED		SHEET 3 OF 5
MFG. APPR.		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
APPROVED		
DE APPR.		
DATE	08.09.18	

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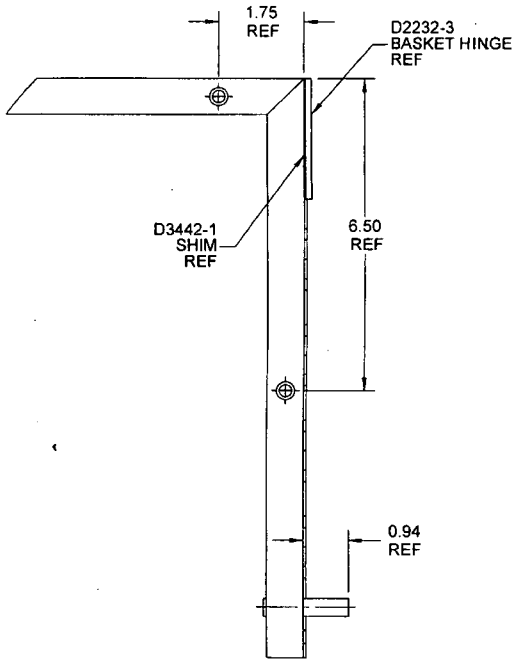
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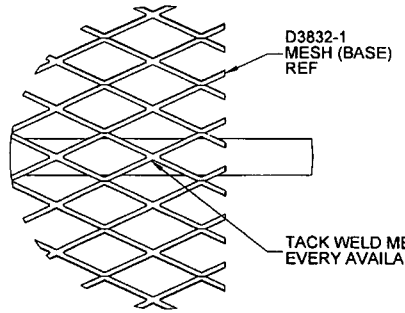
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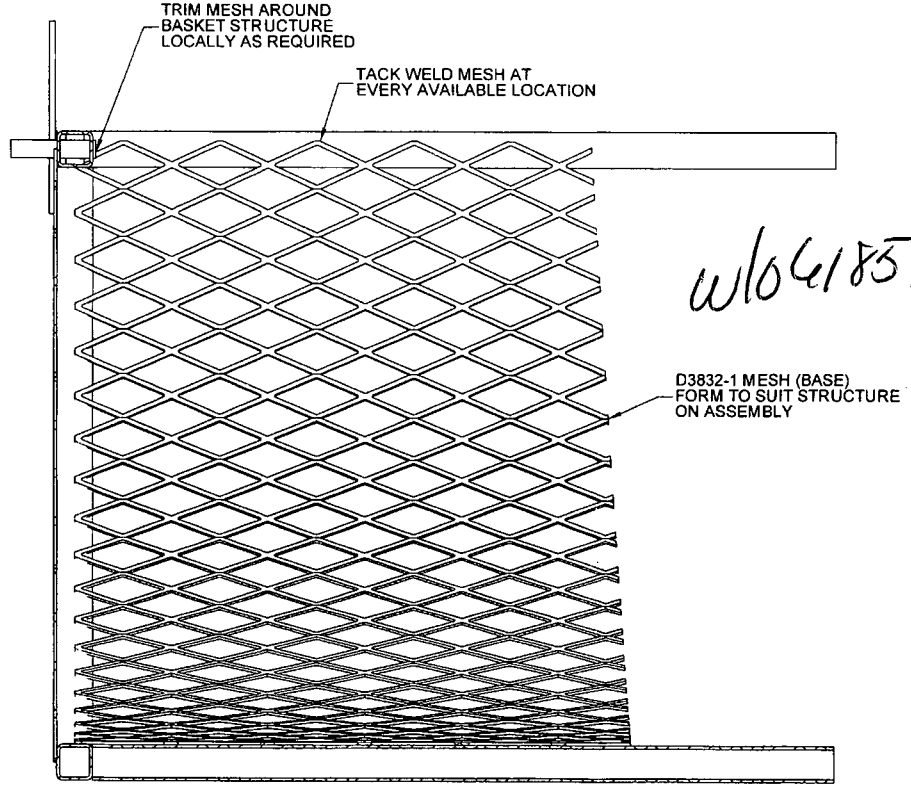
NOTE: Date & initial all entries



H DETAIL D SCALE 4X D2-2



H DETAIL E SCALE 4X C6-2



H SECTION F-F SCALE 4X D7-2

w1041857

RELEASED 02/11/18

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 4 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

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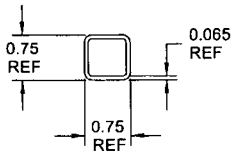
W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

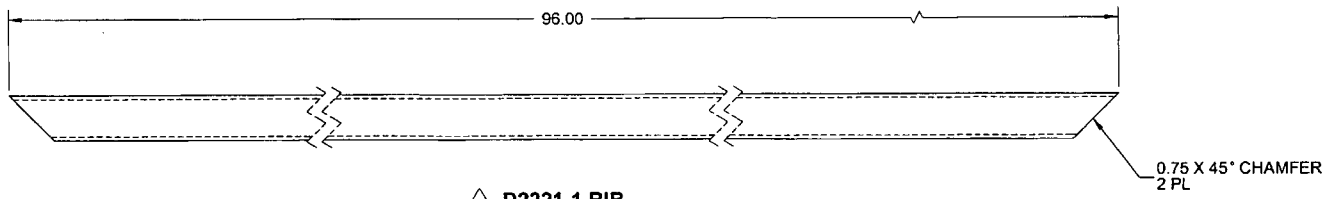
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

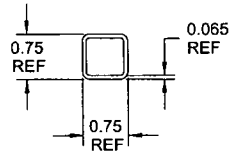
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

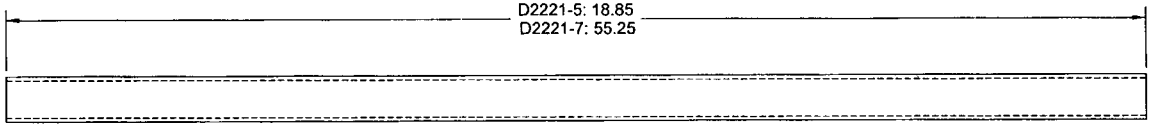
NOTE: Date & initial all entries





H **D2221-1 RIB**





H **D2221-5/-7 RIB**

W1061857

RELEASED 08/11/18 JW

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D2221 REV. H
MFG. APPR.		SHEET 5 OF 5
APPROVED		TITLE BASKET BASE ASSEMBLY (350) SCALE NTS
DE APPR.		
DATE	08.09.18	

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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries